

Work Order ID 76642-*Blut Glossy Blader* *76642*

Page 1

November 18, 2011 10:24:09 AM

Item ID: D2230-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Lug

Start Date: 11/18/11 Start Qty: 200.00

200

Cust Item ID:

Required Date: 11/30/11 Req'd Qty: 200.00

200

Customer:

Reference:

Approvals:

Process Plan: *cd*

Date: 11/18/18

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2230

Rev G

100

0.00

100

BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut D2423 extrusion to 0.82"
Batch: *B68331*

cut @ metec

110

0.00

110

HAAS CNC VERTICAL MACHINING #1

HAAS 1 *Punch*

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio FA927
FOLIO REV: _____
DWG REV: _____
Check for crack while loading into the machine.
2- deburr

P/O: 15479

issue P/O: to metec

machine as per dwg D2230 REV. G

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Run Start ***NR1***

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120 *rec'd*

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

*rec'd + inspect for transit damage
attached c/c to W/O.*

6/11/11/30 (200)

130

QC3- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

W 11. 11. 30 (200)

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

200 X 8 m-11/11/30

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Run Start *NR1*

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop *NR2*

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

2 BL 11-12-8.

170

White Gloss (Ref: 4.3.5.1) per QSI005 4.3-Alum

0.00

170

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Glossy Blk
11:10
3200F
11:40

180

QC3- Inspect Part Finish

0.00

180

QC

Memo

0.00

Quality Control

2xØ m/ 11/12/08

2 BL 11-12-8.

M 118025

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76642

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~~November 18, 2011 10:24:09 AM~~

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Identify as per dwg & Stock Location: _____	0.00							
190									
Packaging	Memo	0.00							
Packaging									
200	QC21- Final Inspection - Work Order Release	0.00							
200									
QC	Memo	0.00							
Quality Control									

Picklist Print

November 18, 2011 10:24:09 AM

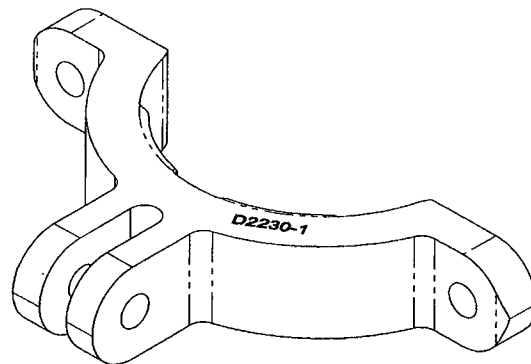
Page 1

Work Order ID: 76642
Parent Item: D2230-3
Parent Item Name: Lug

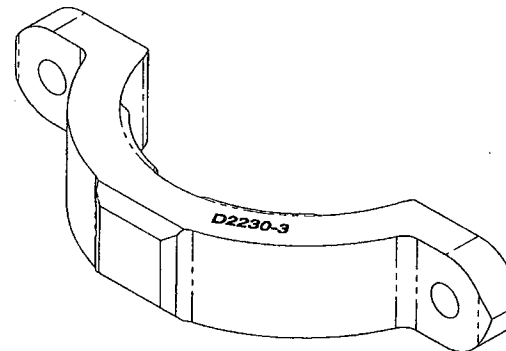
Start Date: 11/18/11 Required Date: 11/30/11
Start Qty: 200.00 Required Qty: 200.00

Comments: IPP D00.05.18 Added inspection level 8, and removed P/O for powder
coatEC IPP REV :E NEW FOLIO # 10-05-25 JLM VERIFIED
BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-3P ✓		Purchased	No				Each	0.0000		200		11/14/30 (200)	
LUG													
D2423		Manufactured	No			100	f	455.0800	0.0683	14.378947		11/11/08	
Lug Extrusion													
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>						
				MAT006	455.08								
				43722	161.5								
				45800	1								
				68331	292.58								
								14.39					



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

*CL 11/18
W10: 76642*

RELEASED
9/18/85

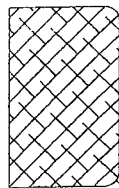


NOTES:

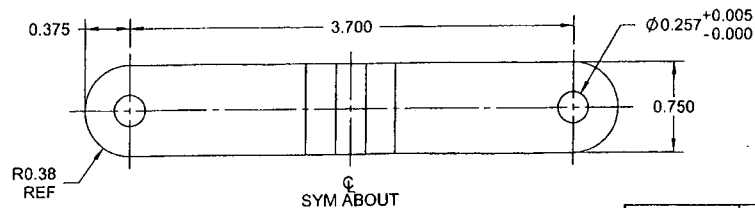
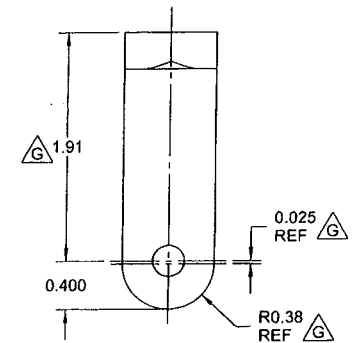
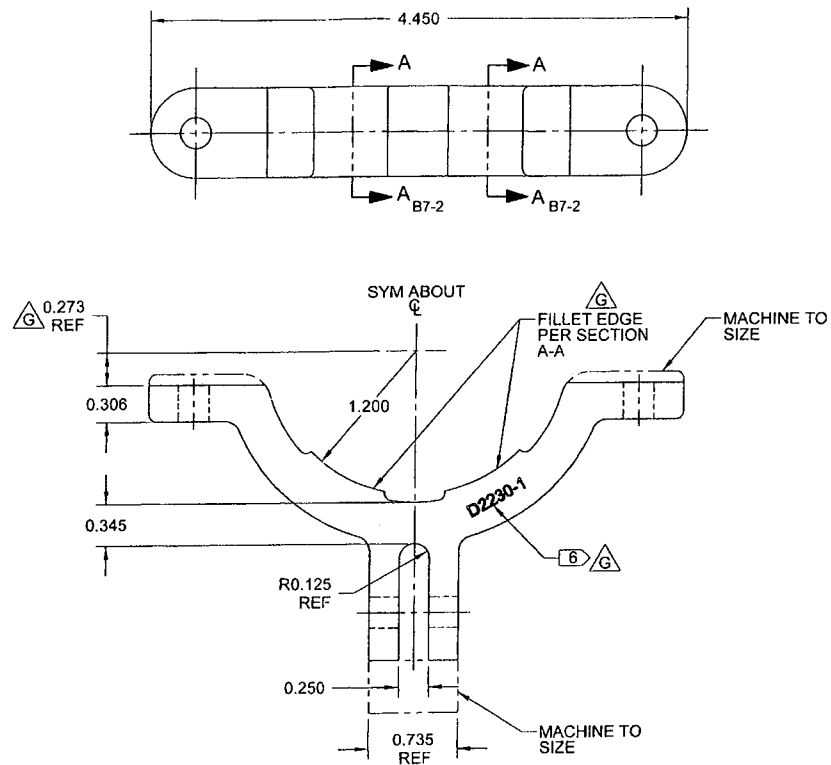
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

REV.	DESCRIPTION	BY	DATE
G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
E	RE-DESIGN	BW	95.01.04
D	RE-DESIGN	BW	95.01.04
C	RE-DESIGN	BW	94.03.30
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D2230 TITLE MOUNTING LUG <small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>	REV. G	SHEET 1 OF 3
DATE	09.01.16	SCALE	NTS

SECTION A-A D4-2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL

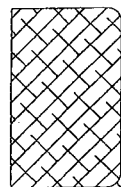


D2230-1 MOUNTING LUG

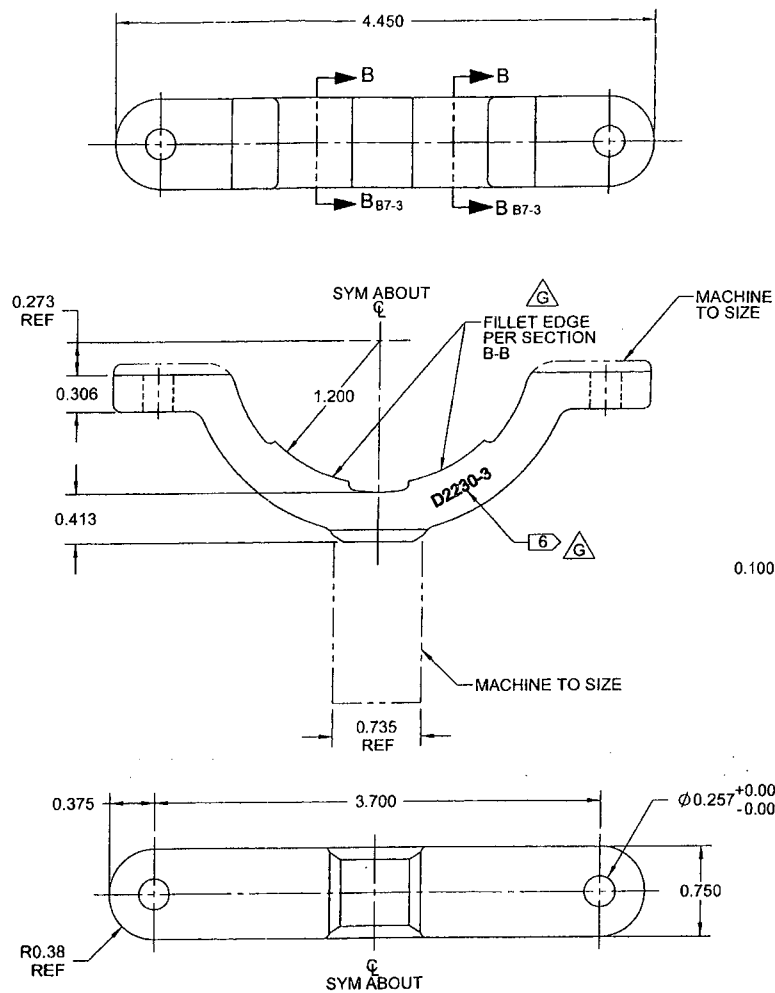
RELEASED
09/06/25

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO. D2230	REV. G
MFG. APPR.		TITLE MOUNTING LUG	SHEET 2 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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SECTION B-B
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
01/04/23

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
DATE	09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITH OUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO15479

Purchase Order Date 11/18/11

PO Print Date 11/18/11

Page Number 1 of 1

VC-MET003

TECHNOLOGY INC.
DRIVE PO BOX 781
L. QC K0B 1R0

613 678 3957
613 678 3956

Buyer Chantal Lavoie
Requisition Nbr
Tax Resale Nbr 10127-2607
Terms Net 30
Currency CAD
FOB Destination-Collect

DAEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

6/11/15

Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
	LUG	11/21/11 Yes	200.00 Each	Dart Truck	\$18.9500	\$3,790.00
	Special Inst:	MACHINE AS PER DWG D2230 REV. G B76640				
	LUG	11/18/11 Yes	200.00 Each	Dart Truck	\$13.6000	\$2,720.00

Special Inst: MACHINE AS PER DWG D2230 REV. G
B76642

PO Total: \$6,510.00

[Faint stamp]

Change Date: 11/18/11

No substitution or deviation without
consent.
Certificate of Conformity or Material
Certification required when applicable



20 Terry Fox Drive
Vankleek Hill, Ontario K0B 1R0 , Canada
Tel: (613) 678-3957
Fax: (613) 678-3956

Delivery Slip No.: **18290**
Date: Nov 30, 2011
Page: 1

Sold to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7	Ship to: Dart Aerospace Ltd. Att. Linda Lacelle 1270 Aberdeen Street Hawkesbury, Ontario K6A 1K7
Order No.: PO15479	Sold By: Dewar, Eric
Shipped By: your truck	Ship Date: Nov 30, 2011

Description	Unit	Ordered quantity	Shipped quantity	Backorder quantity
D2230-1 Mounting Lug, machine as per drawing D2230 REV.G B76640	Each	200		
D2230-3 Mounting Lug, machine as per drawing DWG D2230 REV.G B76642	Each	200	200	
The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.				
Received by _____		Thank you for your order!		



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

<u>QUANTITY</u>	<u>PART NUMBER</u>	<u>PART NAME</u>	<u>P.O. NUMBER</u>
200	D2230-3P	Lug	15479

MATERIAL: supplied by DART D3041 B68331

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

A handwritten signature in black ink, appearing to read "Jan Norris", is written over a horizontal line.

Jan Norris

Vankleek Hill, November 30 2011